

**Work Order ID 47860**

Friday, June 26, 2009 8:59:42 AM

Page 1

Item ID: D350-591-312

Accept

Setup Start

Revision ID: B

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 7/15/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3272	Rev B
-------	-------

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

110

0.00



Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld  
Fwd End Plate as per QSI 004 & Dwg D3272 A/RAluminum  
Rod ~~M106330~~ 3-Grind End Plate flush

120

0.00



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

PD 09-07-06

SEP 09-07-08

BE 09-07-09 (10)

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8 08/07/09 x10 (RH)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

09-07-9

10

BR

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

PZ 09.07.10

10

PZ

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

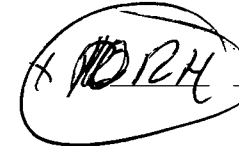


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Assemble Leg Assembly as per Dwg D3272.								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Bevel Aft end for welding Weld Aft End Plate as per QSI 004 & Dwg D3272 Rod <u>M11013C</u> 4-Grind End Plate flush 5-Install last rivet.								

09.07.10

10

09.02.10



10

09.07.13

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Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 7/15/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

D 09-07-13

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=&gt; 809/02/13 (x10 RH)

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

09-07-13

(10)

OK




# Work Order ID 47860

Friday, June 26, 2009 8:59:42 AM



Item ID:	D350-591-312	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Heli-Access-Step, Long RH					
Start Date:	7/15/2009	Start Qty:	10.00		Cust Item ID:	
Required Date:	8/3/2009	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
Powder Coating	Memo START TIME: 8:15am <input type="checkbox"/> OVEN TEMPERATURE: 320°F 8:45am <input type="checkbox"/> FINISH TIME: 11112148 1111472		4P	(X10)	09-07-14	X10			
230	Pressure Wash per QSI005 4.3	0.00							
	WING WALK BATH. 11/013	0.00	BR 09-07-14	(10)					
HandFinish	Memo	0.00							
Hand Finishing									
240	QC3- Inspect Part Finish	0.00							
		0.00	=> 8 09/02/14	(10) RH	p				
QC	Memo	0.00							
Quality Control									

240



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00  
0.00  
=> 8 09/07/14 (X10) RH f

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Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/10 *[Signature]*

MF 09-07-10

# Picklist Print

Page 1

Friday, June 26, 2009 8:59:41 AM

Work Order ID: 47860

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
<i>used</i> D3067-1RevA 		Manufactured	No			110	Each	0.0000	10.0000			
End Plate												
<i>ext. ✓</i> D3272-1RevB 		Manufactured	No			110	Each	0.0000	10.0000			
Step												
<i>✓</i> MS21042L5 <i>x2</i> <i>S 10</i> 		Purchased	No			110	Each	0.0000	20.0000			
Nut												
<i>inst. ✓</i> D3065-041RevB 		Manufactured	No			160	Each	0.0000	10.0000			
Step Leg Assembly Hi												
<i>inst. ✓</i> D3066-1RevB 		Manufactured	No			160	Each	0.0000	20.0000			
Spacer												
<i>used</i> D3219-1RevA 		Manufactured	No			160	Each	0.0000	20.0000			
Plate												
<i>inst. ✓</i> MS20600-AD4W4 		Purchased	No			180	Each	0.0000	160.0000			
Rivets												
<i>✓</i> AN3-35A <i>x2</i> <i>S x10</i> 		Purchased	No			260	Each	0.0000	20.0000			
Bolt												
<i>✓</i> AN4-13A <i>x8</i> <i>S x10</i> 		Purchased	No			260	Each	0.0000	80.0000			
Bolt												

B463413 PD 09.07.06

B48415 AD 09.07.06

M11127 09/07/01 SS.

B47090 \*

\* B47185  
B48103=14 B47785=6

B45357 → 19 PD 09.07.06  
B47296 → 1

M111477

M10467 09/07/01 SS.

M111925 09/07/01 SS.

# Picklist Print

Page 2

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Work Order ID: 47860

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH






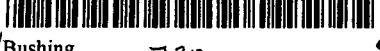



Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN5-36A <i>x2</i> 	<i>S x10</i>	Purchased	No			260	Each	0.0000	20.0000			
Bolt												
✓ AN960JD10 <i>x4</i> 	<i>S x10</i>	Purchased	No			260	Each	0.0000	40.0000			
Washer												
✓ AN960JD416 <i>x16</i> 	<i>S x10</i>	Purchased	No			260	Each	0.0000	160.0000			
Washer												
✓ AN960JD516 <i>x4</i> 	<i>S x10</i>	Purchased	No			260	Each	0.0000	40.0000			
Washer												
✓ D2230-3RevF <i>x4</i> 	<i>S x10</i>	Manufactured	No			260	Each	0.0000	40.0000			
Lug												
✓ D2618RevB1 <i>x2</i> 	<i>S x10</i>	Manufactured	No			260	Each	0.0000	20.0000			
Bushing												
✓ D2856-400RevA <i>720 x2</i> 	<i>S x10</i>	Manufactured	No			260	f	0.0000	6.0000			
Abraison Strip												
✓ D3067-1RevA 		Manufactured	No			260	Each	0.0000	10.0000			
End Plate												
✓ D3235-1RevA <i>x2</i> 	<i>S x10</i>	Manufactured	No			260	Each	0.0000	20.0000			
Mounting Lug												

M111808 09/07/01 *SP*

M111668 09/07/01 *SP*

M111279 09/07/01 *SP*

M111279 09/07/01 *SP*

B47965 09/07/01 *SP*

B45392 09/07/01 *SP*

B46543 09/07/01 *SP*

B46334=3 B48242=7 *11*

B45269 09/07/01 *SP*

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Shop Packet Print

Page 2



# Picklist Print

Page 3

Friday, June 26, 2009 8:59:42 AM

Work Order ID: 47860

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Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3278-041RevC	x1 Sx10	Manufactured	No			260	Each	0.0000	10.0000	1		
Support Assembly												
✓ MS21042L3	x2 Sx10	Purchased	No			260	Each	0.0000	20.0000	9		
Nut												
✓ MS21042L4	x6 Sx10	Purchased	No			260	Each	0.0000	80.0000	8		
Nut												

B47197 09/07/01 SS.

M111274 SS 09/07/01.

M110507 09/07/01 SS.

Friday, June 26, 2009 8:59:42 AM

Shop Packet Print

Page 3

Date: Monday, 11/05/2009 1:22:16 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CC-EUR01 Eurocopter France	<b>Drawing Name</b> : LONG STEP ASSEMBLY HIGH SKID RH
<b>Job Number</b> : 47860	
<b>Estimate Number</b> : 13561	
<b>P.O. Number</b> :	<b>Part Number</b> : D350591312
<b>This Issue</b> : 11/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3272 REV-B-EUROCOPTER
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 47202	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 05/06/2009 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.05.11</u>	
<b>Comment</b> : Est Rev:A 04.03.22 New issue KJ/RF Est Rev:B 07-06-09 Added D3572-1 JLM Est. returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*for a 09/07/06*

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

2.0	D32721	Step
-----	--------	------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STEP

BATCH: B48415

PD 09.07.06

3.0	D30671	End Plate
-----	--------	-----------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate

B16334

PD 09.07.06

4.0	D32191	Plate
-----	--------	-------

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support

B45 397 x19  
B47296 x1 un

PD 09.07.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/05/2009 1:22:16 PM  
User: Julie Dawson

## Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 47860

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272  
A/R Aluminum Rod M106330

PD 09.07.06

3-Grind End Plate flush

SAD 09-07-08

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09-07-09

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/07/09 (L1024)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-7-10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SA 09.07.10

10.0

D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3065-041	Step Leg Assy	347090

SA 09.07.10

11.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3066-1	Spacer	B48103=14 B47185=6

SA 09.07.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_












Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/05/2009 1:22:16 PM  
User: Julie Dawson

## Process Sheet

Customer: CC-EUR01 Eurocopter France		Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH	
Job Number: 47860		Part Number: D350591312	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
12.0	MS20600AD4W4	Rivets	
			
Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s) Pick: Qty Part Number Description Batch 16 MS20600AD4W4 Rivet <u>M111477</u>			
13.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1 Assemble Leg Assembly as per Dwg D3272.			
14.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP			
15.0	D30671	End Plate	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3067-1 End Plate <u>B46334=3</u> <u>B48242=7</u>			
16.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1			
1-Bevel Aft end for welding		<u>PE</u> 09.07.13 10	
2-Inspect for foreign object as per QSI 024		<u>PE</u> 09.07.13 10	
3-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod <u>M110130</u>		<u>PE</u> 09.07.13 10	
4-Grind End Plate flush		<u>PE</u> 09.07.13 10	
5-Install last rivet.		<u>PE</u> 09.07.13 10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 47860

Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11 09-07-13 (10)

18.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/07/13 100%

19.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

20.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:15am

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:45am

9/1 09-07-14 X (OK)

21.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

BR 09-07-14 (100%)

22.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

5 09/07/14 (100%)

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0 D22303 Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 47860

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

✓ D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618

Bushing

26.0

✓ D2856400

Abraison Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Abraison Strip

2 x D2856-400-720

27.0

✓ D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1

Mounting Lug

28.0

✓ D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041

Support Assembly

29.0

✓ AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

30.0

✓ AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 47860

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

✓ AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A Bolt

32.0

✓ AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer

33.0

✓ AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer

34.0

✓ AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

35.0

✓ MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/05/2009 1:22:16 PM  
User: Julie Dawson

## Process Sheet

Customer: CC-EUR01 Eurocopter France

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 47860

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0



MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) \_\_\_\_\_

37.0



MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) \_\_\_\_\_

38.0



QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

805/02/15 (H024)

39.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location: \_\_\_\_\_

40.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>JB</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. *47860*

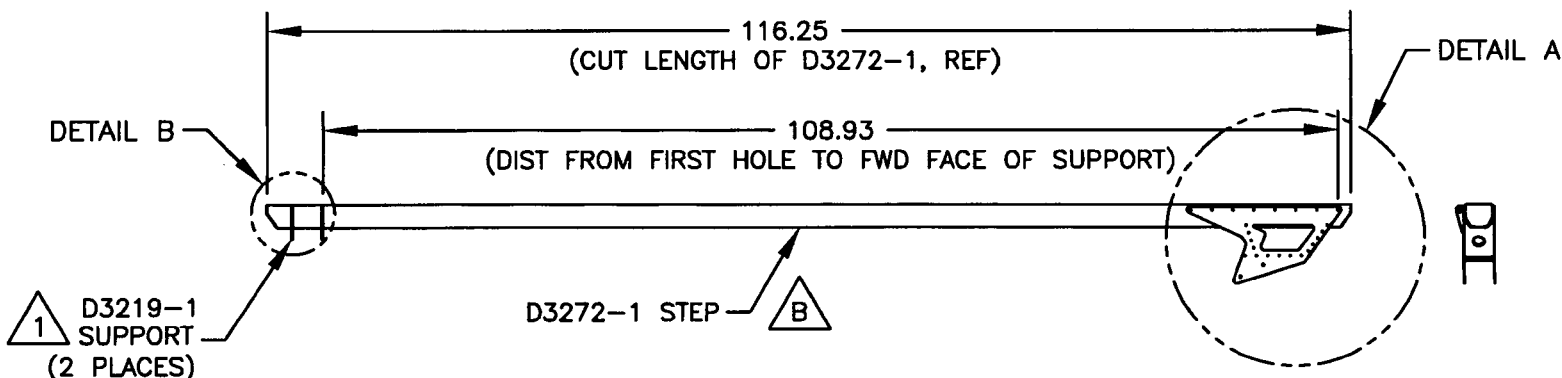
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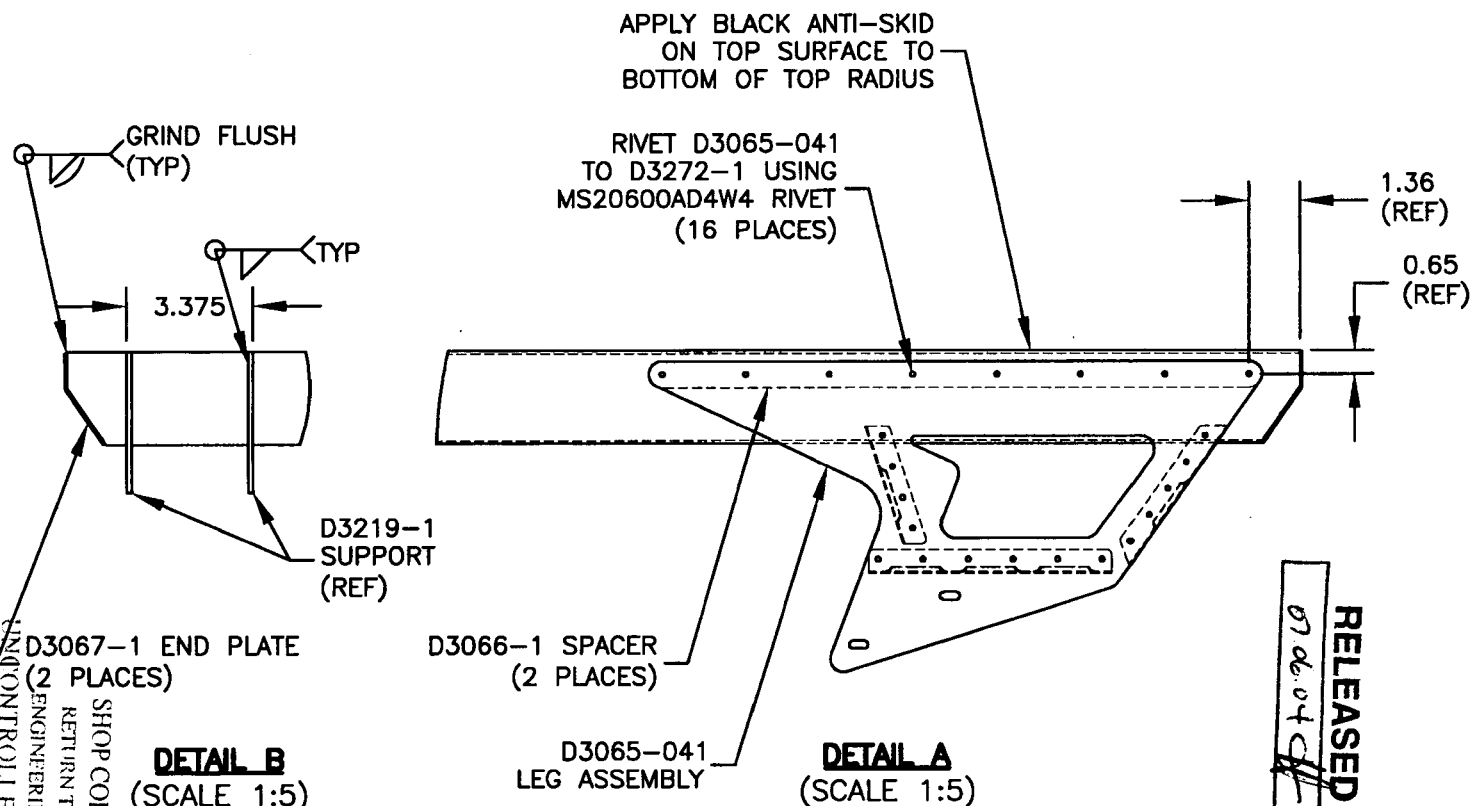




DESIGN	q	DRAWN BY	J	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	J	DRAWING NO. D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B SHEET 2 OF 3
		SCALE	1:20	



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

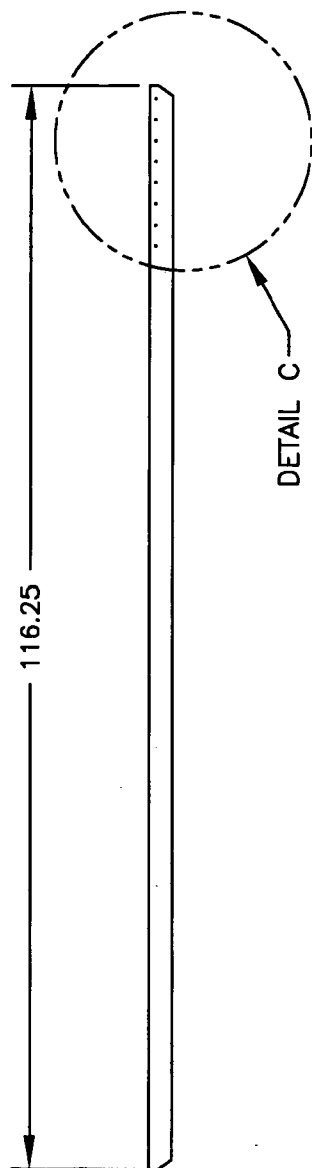




DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

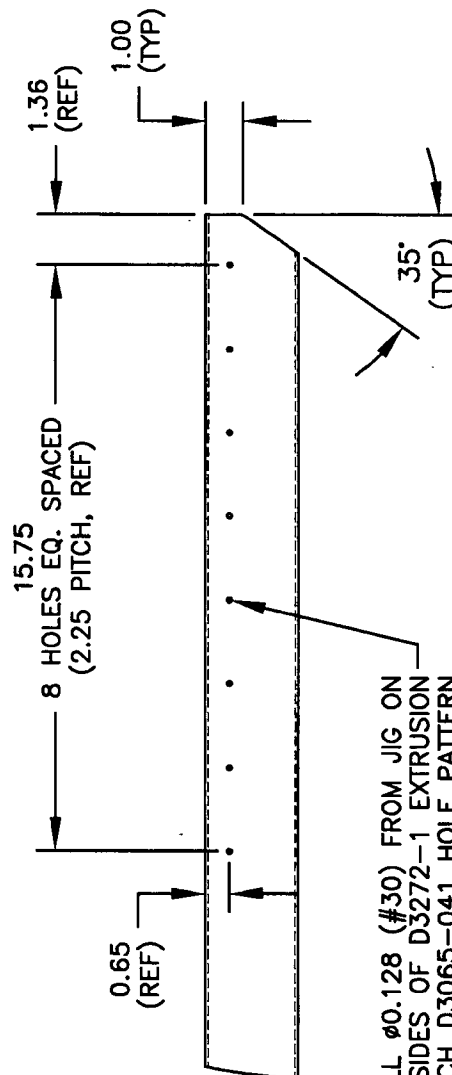
07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)



**DETAIL C**  
(SCALE 1:5)

DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

TOP COPY  
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